



Swing Gear

A high alloy electrode for welding dissimilar steels and unknown steels - high carbon to all steels.

Typical Applications:

Chassis frames, gears, springs, tool steels, dissimilar alloy steels joining.

Outstanding Features:

- Very high tensile strength and ductility.
- Easy strike and re-strike.
- "Cold arc" coating leading to low heat input.
- Superior for joining dissimilar steels.
- Outstanding resistance to shock & impact.
- Easy slag removal.
- High frictional wear resistance.

Recommendation:

For high strength welds & overlays on all steels requiring best possible properties. For leaf and coil springs, vanadium - molybdenum spring steels, mild steel, medium carbon steels and dissimilar steels.

Procedure:

Clean weld area and ensure joint preparation. For certain high strength low alloy steels, preheat up to 150°C is recommended. Hold a short arc. Run stringer beads. Intermittent welding may be used specially on high alloy steels. Cool each pass before chipping slag. Ensure job temperature should not exceed 300°C to get all properties.

Recommended Amperages:

Size (mm)	I - Range	II - Range
2.50	60 - 70	50 - 60
3.15	90 - 100	75 - 90
4.00	110 - 140	90 - 110
5.00	160 - 180	150 - 160

Tensile Strength: 85 Kg/mm²
(1,20,000 psi)